

Date: Thursday, 6/22/2006 9:51:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 27642	
Estimate Number : 10911	
P.O. Number : N/A	Part Number : D3405041
This Issue : 6/22/2006 S.O. No. : N/A	Drawing Number : D3405 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 6/19/2006 Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 26514	Material : N/A
Written By :	Due Date : 7/15/2006
Checked & Approved By :	Qty: 10 Um: Each
Comment : Est A 05.09.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S11GA	304/316 .125 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.1540 sf(s)/Unit Total : 1.5400 sf(s)
 304/316 .125 Sheet

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: DIMENSIONAL CHECK
 Inspect dimensions as per Dwg D3405

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr *SAD 06:07:13*
 Form using DT8204 as per Dwg D3405

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Date: Thursday, 6/22/2006 9:51:53 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 27642

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

B26536

A/R

SS Rod

M13066

PD 06-07-27 (10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

PD 06-07-27 (10)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-07-27 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M. 06-08-01

(10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 6/8/03 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SI 77

PD 06/08/03

(10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PD 06/08/03 (10)

Job Completion



U 06-08-09

Date: Monday, 6/19/2006 11:30:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 27642		
Estimate Number	: 10911		
P.O. Number	:	Part Number	: D3405041
This Issue	: 6/19/2006 S.O. No. :	Drawing Number	: D3405 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 26514	Material	:
Written By	:	Due Date	: 7/15/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>06.06.19</u>		
Comment	: Est A 05.09.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING (MBO/S116A). 304 SS. 0.125" THK
 Issue P/O: _____ (.154 SF)
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3405 Batch: M6789
 Material release note is required M101463
 Identify as D3405-1 M 06 07 01

2.0	D34051F	GHW Bracket
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Water Jet A
Dwg Rev. A
PRG Rev. A

M 06 07 01



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 G H W BRACKET

3.0	PACKAGING 1	QC2	PACKAGING RESOURCE #1
-----	-------------	-----	-----------------------



M 06 07 01



Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0	Q66	DIMENSIONAL CHECK
-----	-----	-------------------

PCB



Comment: DIMENSIONAL CHECK
 Inspect dimensions as per Dwg D3405

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr
 Form using DT8204 as per Dwg D3405

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:30:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 27642

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

A/R

SS Rod

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:30:37 AM
User: Kim Johnston

Process Sheet

• Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 27642

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

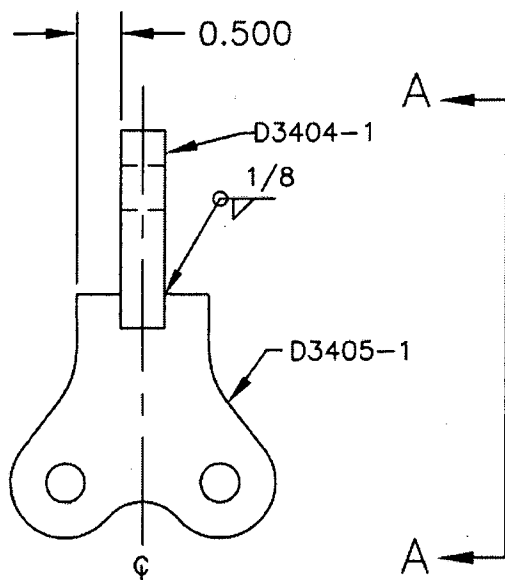
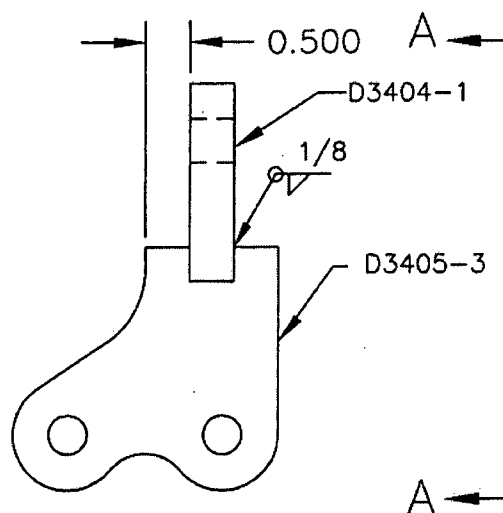
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: SD Date: 06/08/08

NOTE: Date & initial all entries

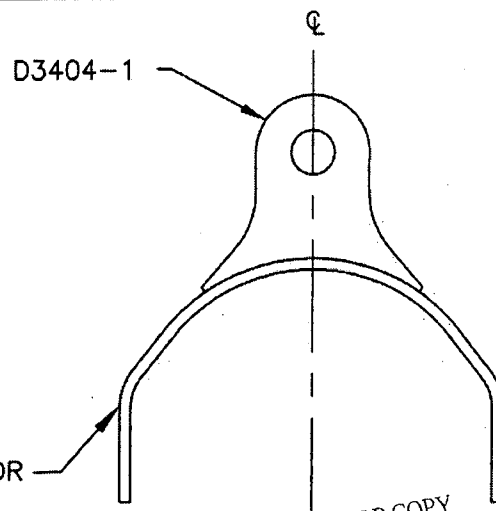
QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09D3405-1 OR
D3405-3

SHOP COPY
RETURN TO
VIEW AREA
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27642

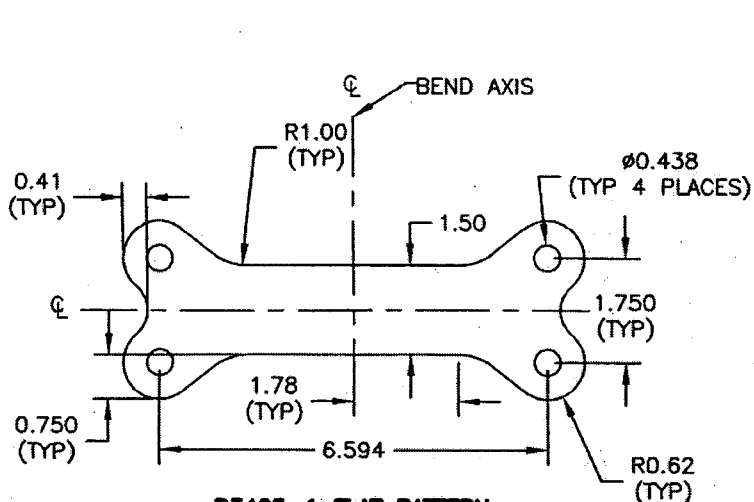
D3405-041/-043 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

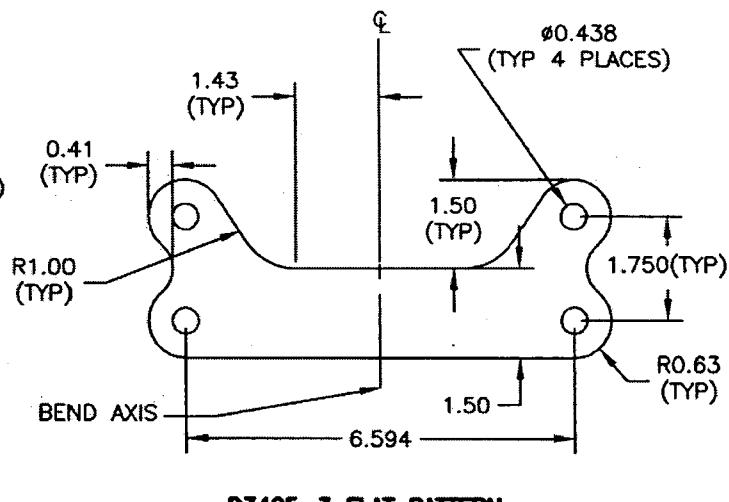
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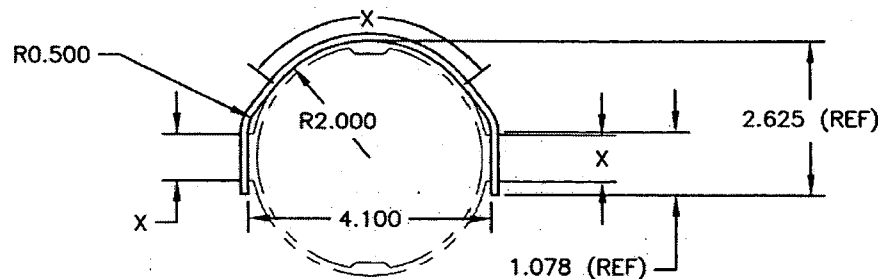
DART



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/- GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-08-04
SUBJECT TO AMENDMENT
WITHOUT NOTICE

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
WORK ORDER
NO. 27642

DESIGN	DRAWN BY	TITLE	REV. A
PH	PH	DART AEROSPACE USA, INC. PORT HADLOCK, MA	
CHECKED	APPROVED	DRAWING NO. D3405	SHEET 2 OF 2
DATE 05.03.08		GHW LUG ASSEMBLY	SCALE 1:3

